

Appln No. 10/571,985
Amdt date March 23, 2011
Reply to Office action of January 03, 2011

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claims 1-18 (Canceled)

19. (Currently Amended) A molded container for liquid infusion, said container comprising a plurality of walls including a first side wall and a second side wall, two collapsible walls each being disposed in between the first side wall and the second side wall, a bottom wall configured for standing upright, and a shoulder portion having a port for filling fluid into or discharging fluid out of an interior cavity defined by the plurality of walls, wherein the bottom wall comprises an interior wall surface and an exterior wall surface and a fold line separating the interior wall surface into a first interior section and a second interior section and at least two transverse fold lines that are angled to one another; and wherein portions of the first interior section and the second interior section of the bottom wall move closer to one another and wherein portions of the exterior wall surface of the bottom wall move outwardly away from the interior cavity from a first position relative to the interior cavity to a second further outward position relative to the interior cavity when the container collapses.

20. (Previously Presented) The container of claim 19, wherein the fold line is formed by a weakened portion in the bottom wall.

21. (Previously Presented) The container of claim 20, wherein the two collapsible walls each comprises two or more fold lines.

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22. (Previously Presented) The container of claim 21, wherein the fold lines are arranged in a group such that they form an accordion-like folding.

23. (Currently Amended) The container of claim 19, wherein the ~~bottom wall further comprises a transverse fold~~ lines that moves outward during flattening.

24. (Previously Presented) The container of claim 19, wherein the two collapsible walls each comprises a fold line that extends as a longitudinal fold from the bottom wall into the shoulder portion.

25. (Previously Presented) The container of one of claim 19, wherein when the container is filled, the container contains a volume of air of at most 15% of the container volume.

26. (Previously Presented) The container of claim 19, wherein the filling volume of the container is 1 ml to 5000 ml.

27. (Previously Presented) The container of claim 19, wherein the port comprises a pierceable membrane.

28. (Previously Presented) The container of claim 19, wherein the bottom wall comprises a projecting suspension lug.

29. (Currently Amended) A method for manufacturing a molded standing container for infusion liquids comprising the steps:

extruding a preform of a polymer material; and

expanding the preform by blow molding to form the container, the container comprising a plurality of side walls and a bottom wall defining an interior cavity, the bottom wall comprising a rectangular perimeter attached to the plurality of side walls and a fold line located on the

bottom wall away from the perimeter comprising a weakened portion configured so that portions of the bottom wall fold at the fold line and move radially away from the interior cavity from a first position relative to the interior cavity to a second further outward position relative to the interior cavity when the container collapses.

30. (Previously Presented) The method of claim 29, wherein the plurality of walls are made with a wall thickness of about 0.1 mm to about 0.7 mm.

31. (Previously Presented) The method of claim 29, wherein the container is transparent and the transparency is increased by axially stretching the preform.

32. (Previously Presented) The method of claim 29, wherein the preform is a multi-layer preform comprising an overall wall thickness.

33. (Previously Presented) The method of claim 32, wherein at least one of the layers is a layer of adhesive agent.

34. (Previously Presented) The method of claim 32, wherein at least one of the layers is made from a polyamide or an ethylene/vinyl alcohol material.

35. (Previously Presented) The method of claim 32, wherein an outer layer is made of a polyamide or a polyester material.

36. (Previously Presented) The method of claim 32, wherein 40% to 70% of the overall wall thickness is made up by an inner layer, 10% by a barrier layer and at least one layer of adhesive agent, and an outer layer of remaining balance of thickness.

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37. (Previously Presented) A method for filling a container of claim 19 with infusion liquid, characterized in that the container is impressed after molding to reduce its volume and is filled and closed in this state, the impressing providing for a backup volume for receiving a supplementary volume injected later.

38. (Currently Amended) A molded container for liquid infusion, said container comprising a plurality of side walls and a bottom wall defining an interior cavity, the bottom wall comprising an exterior surface and an interior surface, and a shoulder portion of reduced cross-section forming a discharge end; said plurality of side walls comprising ~~means~~ a fold line for collapsing at least two of said side walls; and said bottom wall comprising ~~means~~ a plurality of fold lines for folding with at least two of the fold lines angled to one another, wherein when the container is emptied, such that portions of the exterior surface are configured to move outwardly away from the interior cavity from a first position relative to the interior cavity to a second further outward position when the container collapses; and wherein the bottom wall is folded along the plurality of fold lines.

39. (Previously Presented) The container of claim 38, wherein the plurality of side walls are integrally formed.

40. (Previously Presented) The container of claim 38, wherein the plurality of side walls are made from a multi-layer preform.

41. (Previously Presented) The container of claim 38, wherein the discharge end comprises two ports.

42. (Canceled)